

Work Order ID 63033

Monday, October 18, 2010 1:00:28 PM



Page 1

Item ID: D3574-1

Accept



Setup

Start



Stop



Revision ID:

Item Name: Cabin Floor Protector

Start Date: 10/18/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10/18

Tooling:

Date:

Run

Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

Draw Nbr	Revision Nbr
D3574	Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

BS 10-10-20

FLOW CNC Waterjet

1-Cut as per Dwg D3574 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

(4)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

BS 10-10-20

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

4

Quality Control

4/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3574-1

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Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

150



Identify as per dwg & Stock Location: _____

0.00

Packaging

Packaging

Memo

0.00

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Work Order ID 63033

Page 3

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Item ID: D3574-1

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Setup

Stop



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Item Name: Cabin Floor Protector

Start Date: 10/18/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

10/10/2010

MF

10-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, October 18, 2010 1:00:33 PM

Page 1

Work Order ID: 63033



Parent Item: D3574-1



Parent Item Name: Cabin Floor Protector

Start Date: 10/18/2010

Required Date: 10/26/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.I25-F60029-04 GE PLASTICS LEXAN SHEET		Purchased		No			sf	1,865.803	33.6	134.4672		1810-10-20	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	1865.8038	
115261	1865.8038	

(15261)

(4)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	63033
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574	Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	X		U R02	
7.37	+/-0.030	7.37	X		T R01	
10.75	+/-0.030	10.75	Ø		T	
11.00	+/-0.030	11.00	X		T	
15.25	+/-0.030	15.25	X		T	
25.87	+/-0.030	25.87	X		T	
39.75	+/-0.030	39.75	*		T	
44.75	+/-0.030	44.75	*		T	
49.11	+/-0.030	49.11	*		T	
51.11	+/-0.030	51.11	X		T	
53.51	+/-0.030	53.51	*		T	
63.50	+/-0.030	63.50	X		T	
65.25	+/-0.030	65.25	*		T	
10.75	+/-0.030	10.75	*		T	
11.06	+/-0.030	11.06	*		T	
14.75	+/-0.030	14.75	X		T	
25.50	+/-0.030	25.50	X		T	
25.75	+/-0.030	25.75	X		T	
26.00	+/-0.030	26.00	X		T	
32.87	+/-0.030	32.87	X		T	
38.81	+/-0.030	38.81	*		T	
44.75	+/-0.030	44.75	*		T	
45.00	+/-0.030	45.00	*		T	
48.25	+/-0.030	48.25	X		T	
58.38	+/-0.030	58.38	Ø		T	
61.25	+/-0.030	61.25	X		T	
64.13	+/-0.030	64.13	X		T	
64.63	+/-0.030	64.63	Ø		T	
66.50	+/-0.030	66.50	Ø		T	
7.50	+/-0.030	7.50	X		T	
9.50	+/-0.030	9.50	X		T	
10.38	+/-0.030	10.38	*		T	
10.88	+/-0.030	10.88	Ø		T	
14.50	+/-0.030	14.50	Ø		T	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	63033
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574	Rev: B		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56	X		T B01	
18.75	+/-0.030	18.75	X		T	
24.13	+/-0.030	24.13	D		T	
26.50	+/-0.030	26.50	X		T	
30.50	+/-0.030	30.50	D		T	
33.88	+/-0.030	33.88	X		T	
39.50	+/-0.030	39.50	X		T	
40.25	+/-0.030	40.25	X		T	
43.50	+/-0.030	43.50	A		T	
43.83	+/-0.030	43.83	A		T	
46.60	+/-0.030	46.60	A		T	
7.63	+/-0.030	7.63	A		T	
11.00	+/-0.030	11.00	A		T	
11.50	+/-0.030	11.50	A		T	
16.75	+/-0.030	16.75	D		T	
19.00	+/-0.030	19.00	A		T	
22.50	+/-0.030	22.50	X		T	
30.75	+/-0.030	30.75	D		T	
32.63	+/-0.030	32.63	X		T	
32.75	+/-0.030	32.75	X		T	
35.13	+/-0.030	35.13	X		T	
36.50	+/-0.030	36.50	D		T	
40.00	+/-0.030	40.00	D		T	
41.88	+/-0.030	41.88	D		T	
43.63	+/-0.030	43.63	X		T	
0.125	+/-0.010	1.31	X		V+B02	

Measured by:	HB	Audited by:		Prototype Approval:	N/A
Date:	10-10-20	Date:	10-10-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	M

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

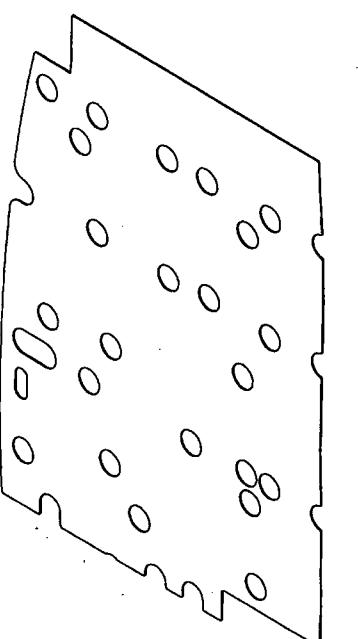
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP CONSTRUCTION

REV. 3

ENCL. 1



UNCONTRACTED

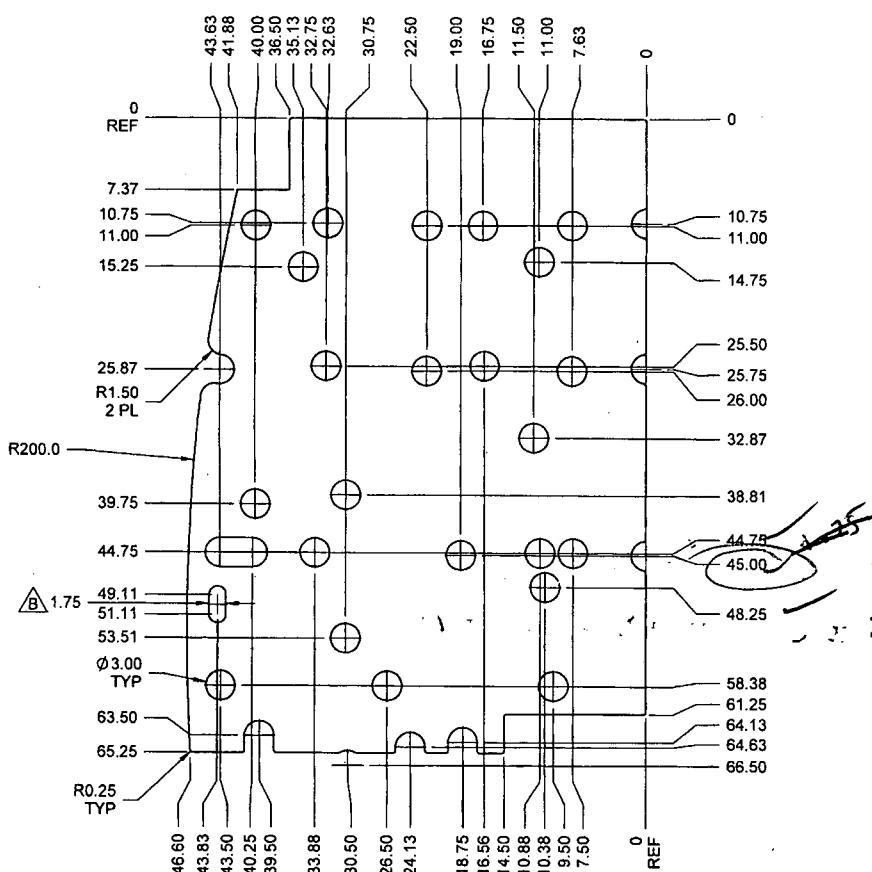
SUB. 1

V

W

NO. 63083

28/10/08

RELEASED
01/01/07 AMD3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

B	ADD CUT-OUT TO -1/4 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2	<input checked="" type="checkbox"/>	08.03.25
A	NEW ISSUE	<input type="checkbox"/>	CB 07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<input checked="" type="checkbox"/>	DART AEROSPACE LTD	
DRAWN	<input checked="" type="checkbox"/>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO.	REV. B
MFG. APPR.	<input checked="" type="checkbox"/>	D3574	SHEET 1 OF 6
APPROVED	<input checked="" type="checkbox"/>	TITLE	SCALE
DE APPR.	<input checked="" type="checkbox"/>	CABIN FLOOR PROTECTOR NTS	
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

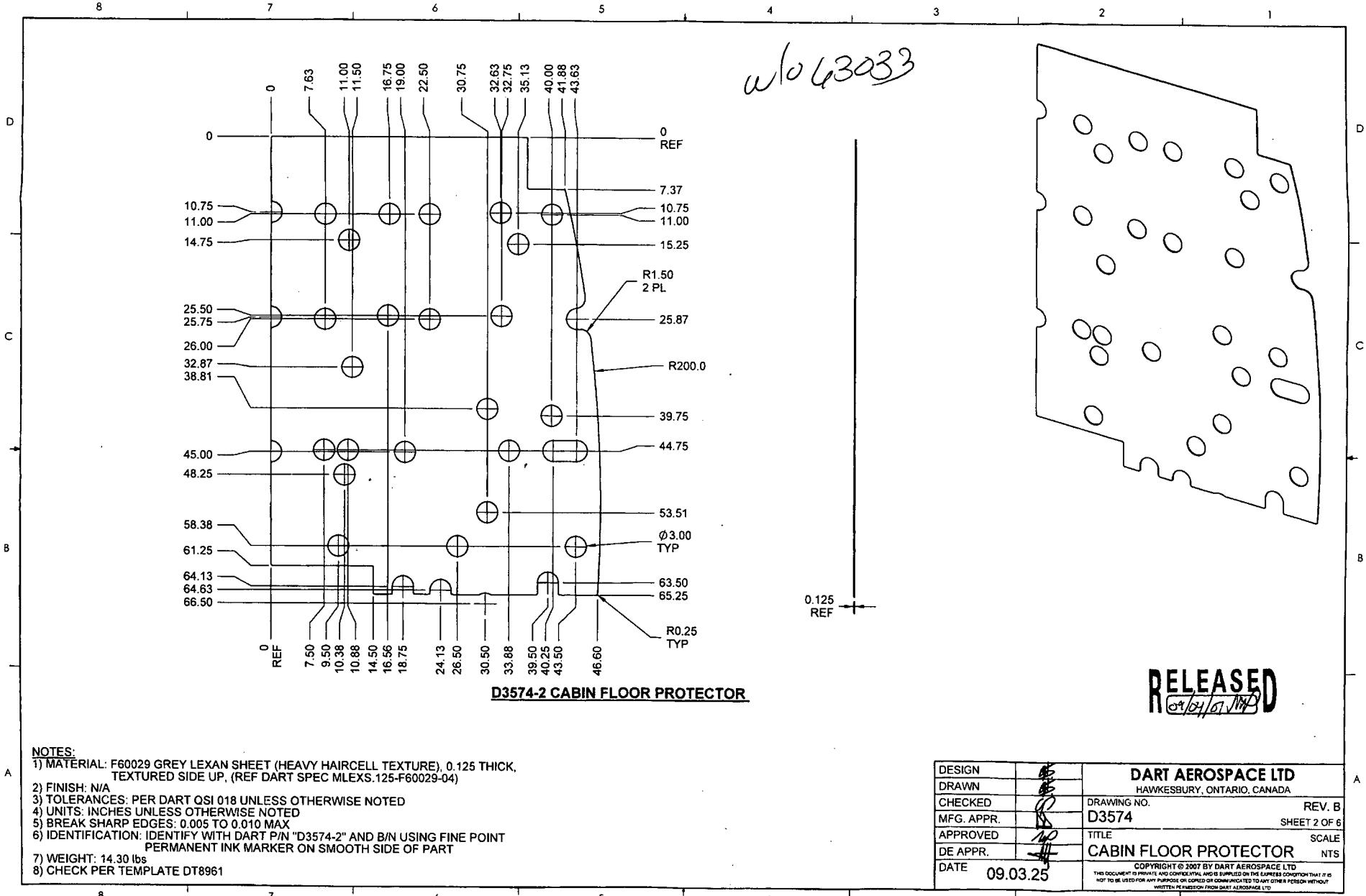
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3574 SHEET 2 OF 6
APPROVED		TITLE
DE APPR.		SCALE
DATE	09.03.25	CABIN FLOOR PROTECTOR NTS

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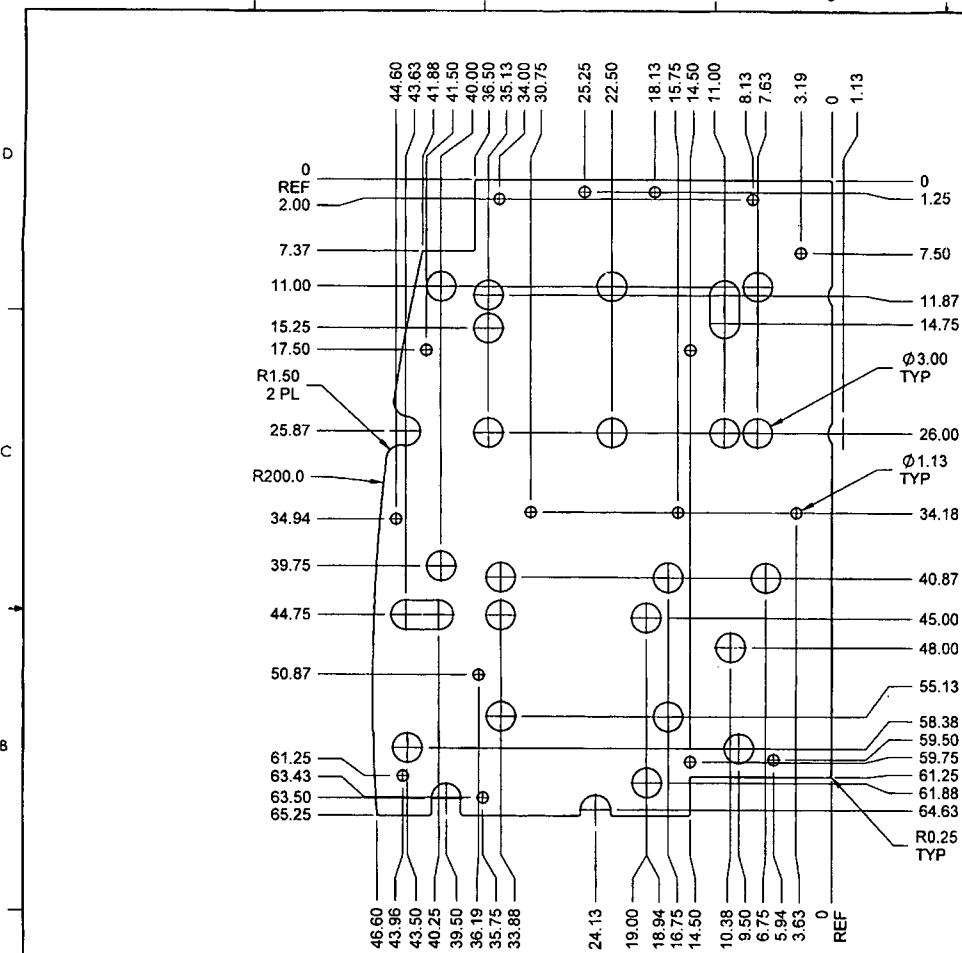
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

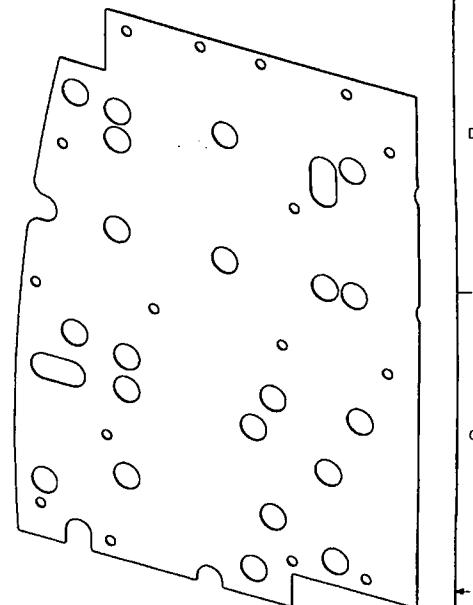
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Ab 43033



RELEASED
06/07 HHD

D3574-3 CABIN FLOOR PROTECTOR

NOTES:

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK
TEXTURED SIDE UP. (REF DART SPEC MLEXS 125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT
PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962

DESIGN	<i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>BS</i>			
CHECKED	<i>RR</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>BS</i>	D3574	SHEET 3 OF 6	
APPROVED	<i>AD</i>	TITLE	SCALE	
DE APPR.	<i>AD</i>	CABIN FLOOR PROTECTOR		
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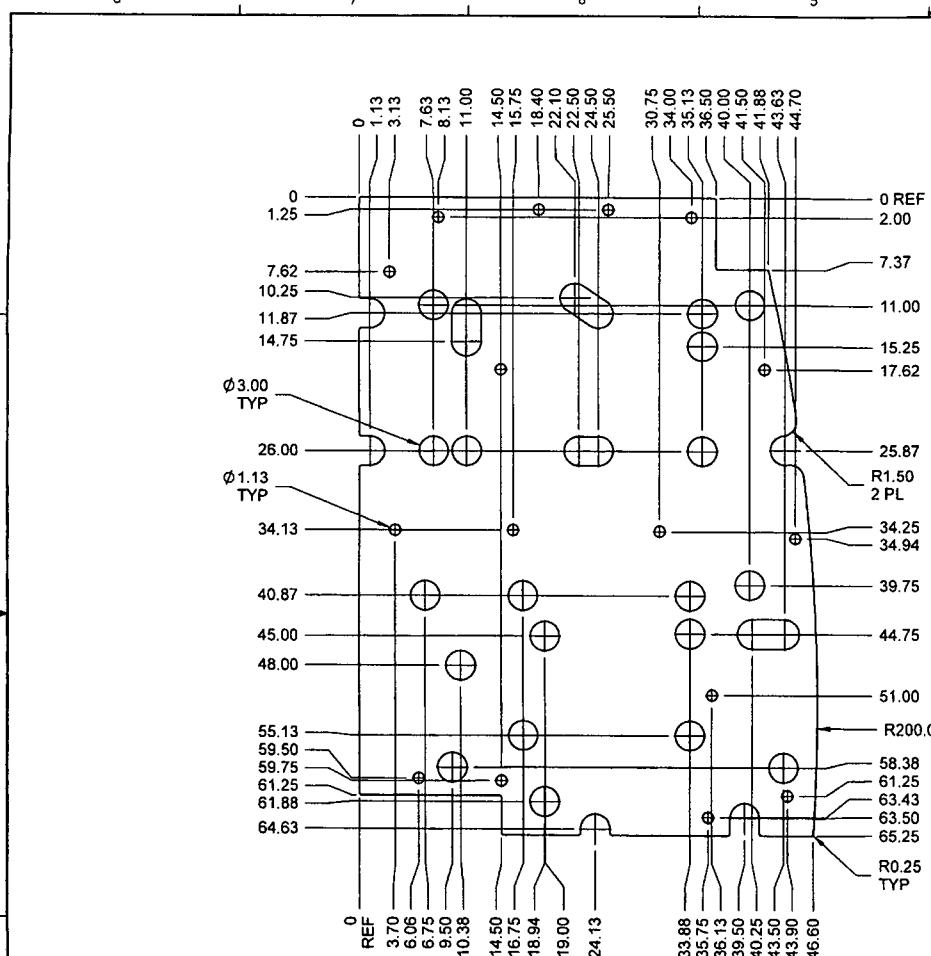
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

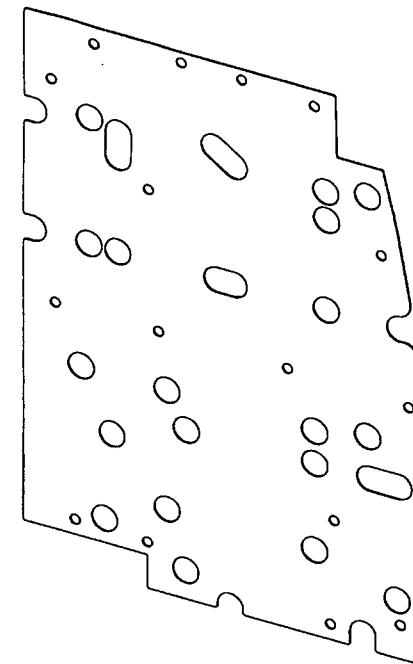
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



W043033



0.125
REF

RELEASED
09/03/07

D3574-4 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.18 lbs
- 8) CHECK PER TEMPLATE DT8963

DESIGN	<input checked="" type="checkbox"/>	DART AEROSPACE LTD
DRAWN	<input checked="" type="checkbox"/>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO. REV. B
MFG. APPR.	<input checked="" type="checkbox"/>	D3574 SHEET 4 OF 6
APPROVED	<input checked="" type="checkbox"/>	TITLE SCALE
DE APPR.	<input checked="" type="checkbox"/>	CABIN FLOOR PROTECTOR NTS
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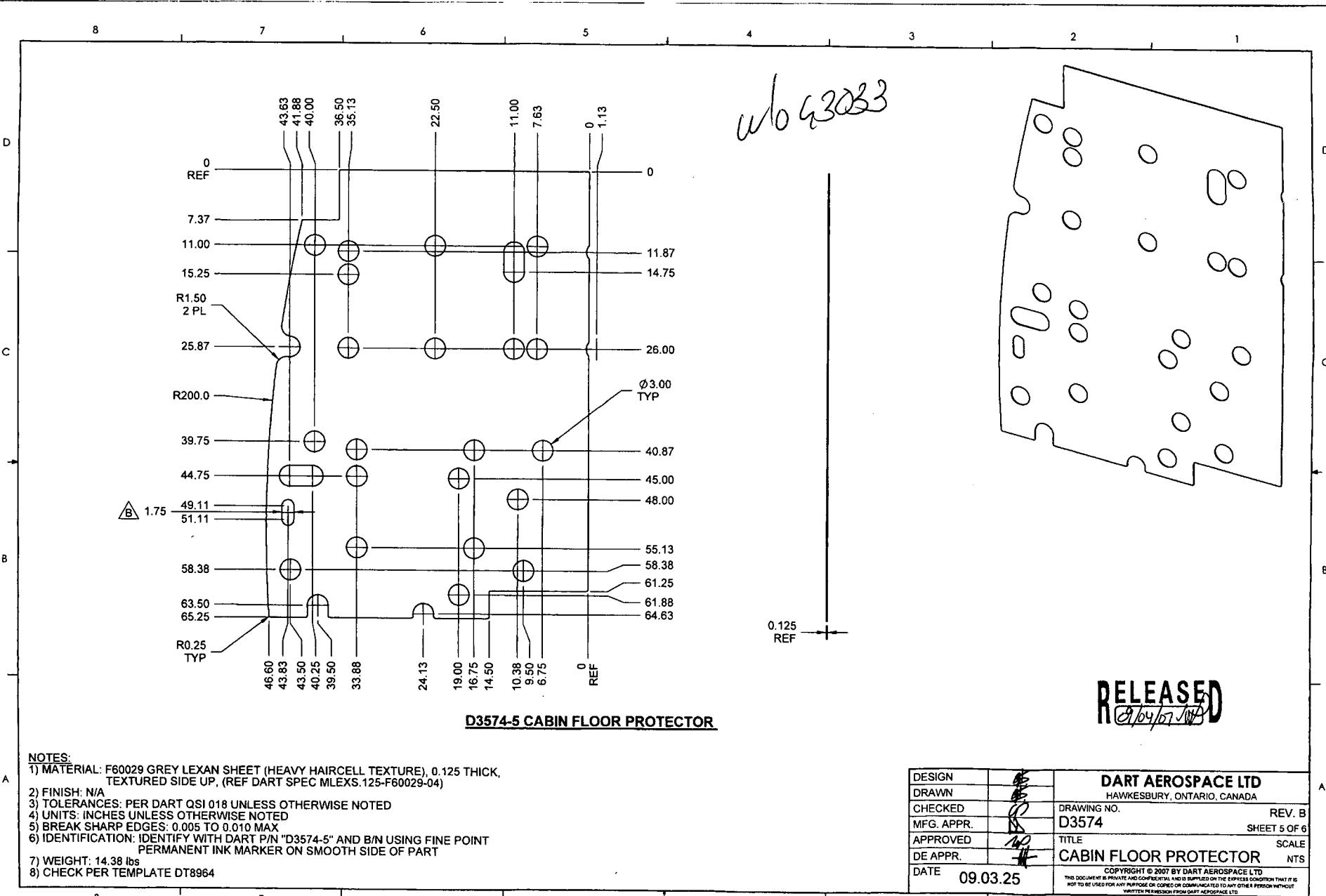
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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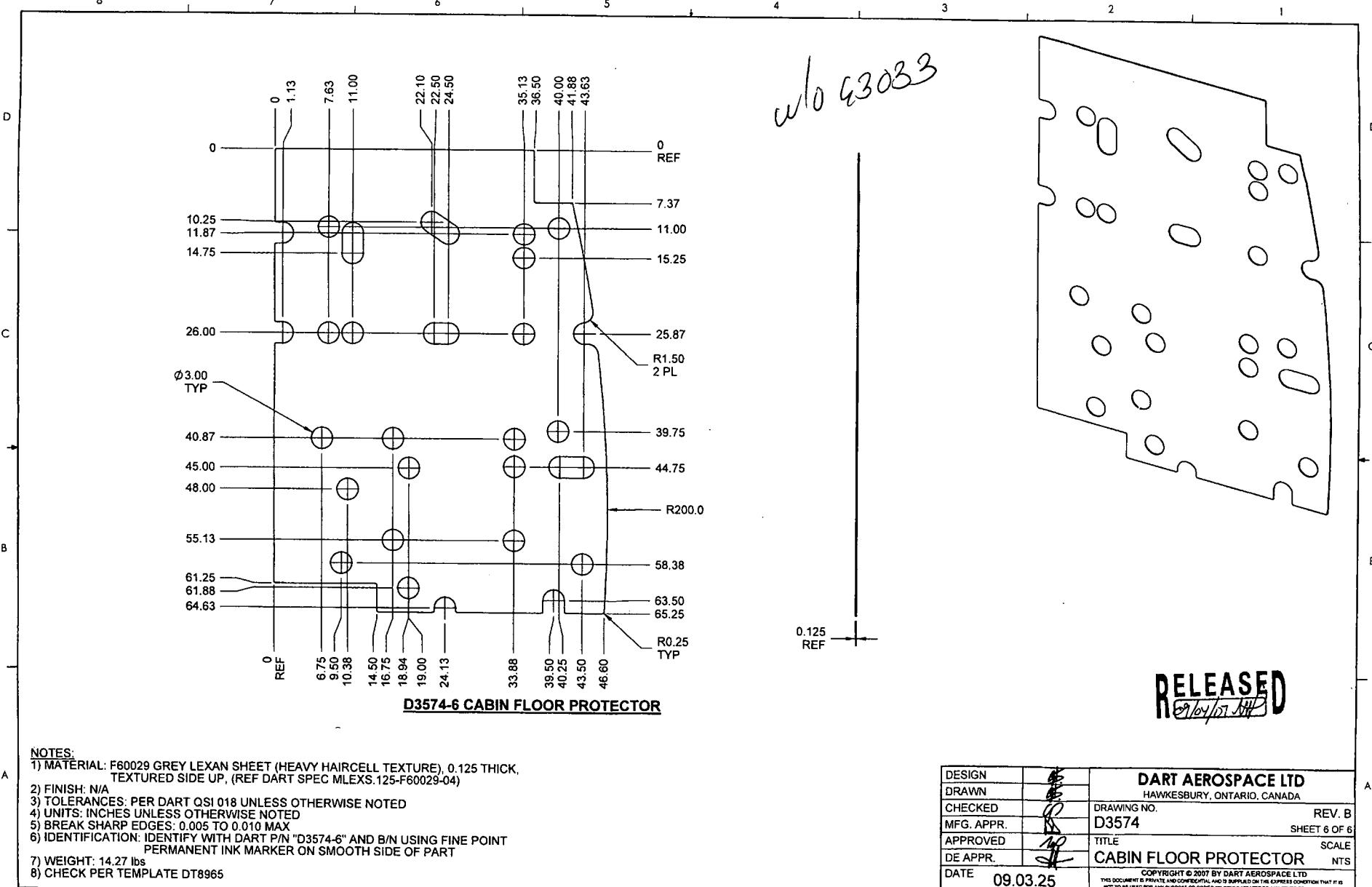
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DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D3574 REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE CABIN FLOOR PROTECTOR NTS
DE APPR.	<i>[Signature]</i>	SCALE
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W/O:		WORK ORDER CHANGES					
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